



DESIGN #1	DRAWN BY CR	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #1	APPROVED CR	DRAWING NO. D2790	REV. B SHEET 1 OF 2
DATE 98.11.26		TITLE 427 FLOAT SKIDTUBE ASSEMBLY SCALE NTS	
A	98.08.13	NEW ISSUE	
B	98.11.26	R30.0 WAS R18.5	

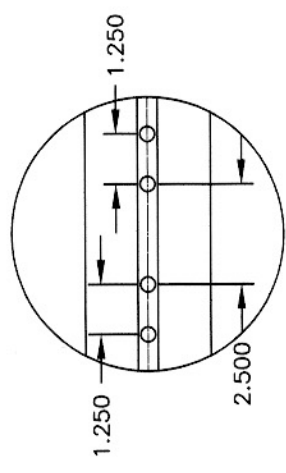
RELEASED
99.03.01 DS

Qty	Part Number	Description
X	D2790-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP
3	D2648-3	WEARPAD
2	D2648-5	WEARPAD
49	D2649	CROSS BOLT SPACER
8	D2651-1	PLUG
8	D2651-3	O-RING
1	D2789	WEB
1	D2791	WEARPAD
1	D2793	CAP
54	ALS4-1032-130 or AKS7-1032-130	INSERT
56	AN960JD10L	WASHER
56	MS27039-1-08	SCREW

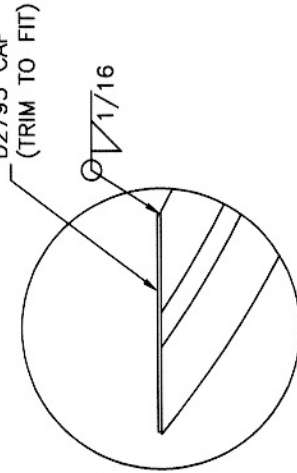
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 200 INCHES.*
- 3) INSERT D2789 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING.
- 4) USE DART DRILL TEMPLATE DT8161 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS4-1032-130 PER SECTION D-D (54 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2789 WEB.
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (8 PLACES).

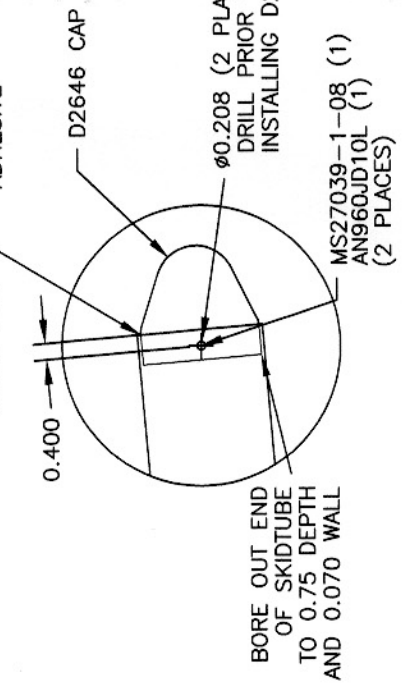
DETAIL A
SCALE 5:24



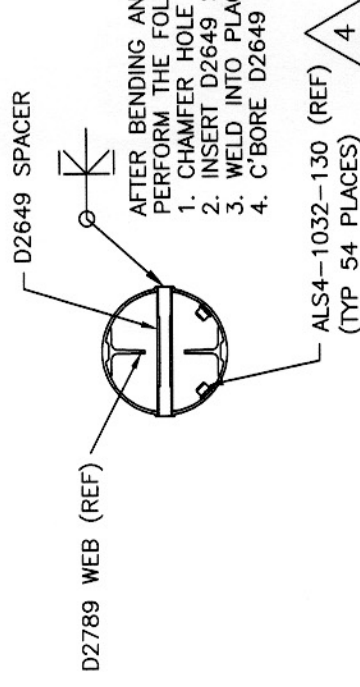
DETAIL B
SCALE 5:24



DETAIL C
SCALE 5:24



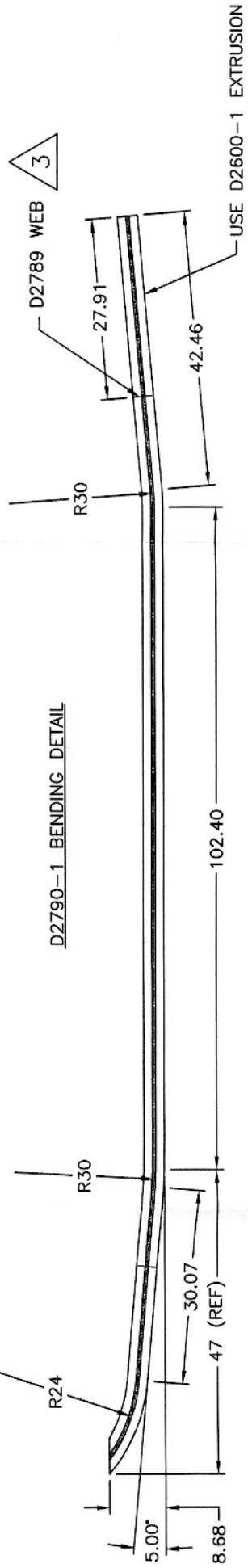
SECTION D-D
SCALE 5:24
FOR $\phi 0.375$ HOLES ONLY



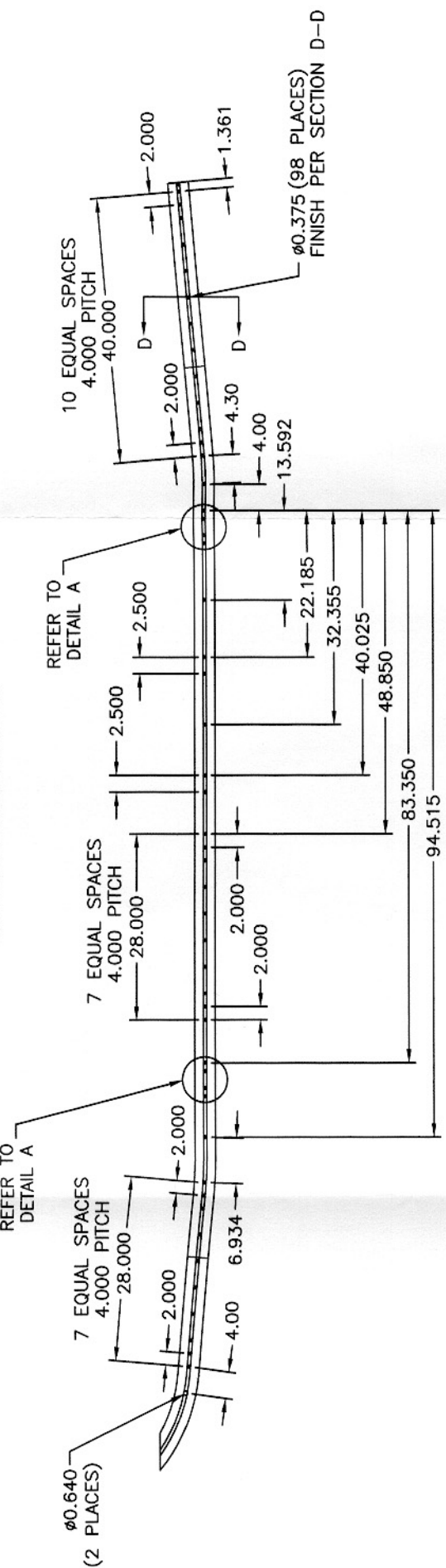
- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.375$ HOLES ONLY:
1. CHAMFER HOLE $0.030 \times 45^\circ$
 2. INSERT D2649 SPACER (49 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2649 SPACER TO $\phi 0.313 \times 0.75$ DEEP

ALS4-1032-130 (REF)
(TYP 54 PLACES)

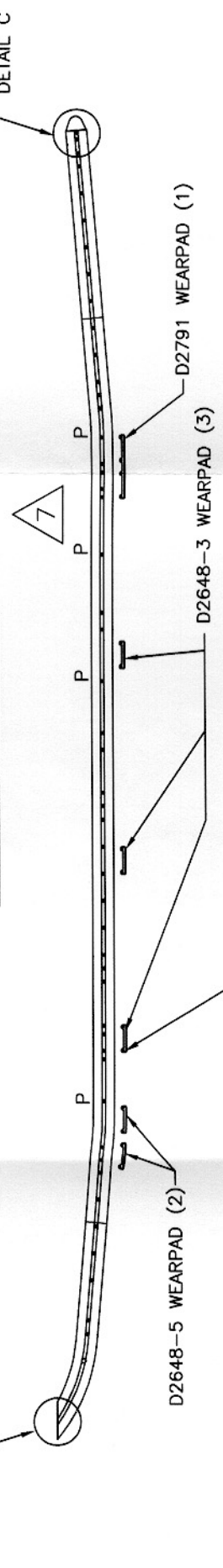
D2790-1 BENDING DETAIL



D2790-1 DRILLING DETAIL



D2790-041 ASSEMBLY DETAIL



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CHECKED	APPROVED	DRAWING NO.	D2790
DATE		TITLE	427 FLOAT SKIDTUBE ASSEMBLY
98.11.26		SCALE	1:24